Section 1. Registration Information

Source Identification

Facility Name:

Valley Fruit III, LLC

Parent Company #1 Name: Parent Company #2 Name:

Submission and Acceptance

Submission Type: Re-submission

Subsequent RMP Submission Reason: 5-year update (40 CFR 68.190(b)(1))

Description:

Receipt Date: 03-Jan-2013
Postmark Date: 03-Jan-2013
Next Due Date: 03-Jan-2018
Completeness Check Date: 03-Jan-2013

Complete RMP: Yes

De-Registration / Closed Reason:

De-Registration / Closed Reason Other Text:

De-Registered / Closed Date:

De-Registered / Closed Effective Date:

Certification Received: Yes

Facility Identification

EPA Facility Identifier: 1000 0017 1075

Other EPA Systems Facility ID:

Facility Registry System ID: 1100 0205 3722

Dun and Bradstreet Numbers (DUNS)

Facility DUNS: 147656284

Parent Company #1 DUNS: Parent Company #2 DUNS:

Facility Location Address

Street 1: 12 Hoffer Road

Street 2:

City: Wapato

State: WASHINGTON

 ZIP:
 98951

 ZIP4:
 9519

 County:
 YAKIMA

Facility Latitude and Longitude

Latitude (decimal):

Longitude (decimal):

Lat/Long Method:

Lat/Long Description:

46.438810

-120.429850

GPS - Unspecified

Center of Facility

Horizontal Accuracy Measure: 6

Horizontal Reference Datum Name: World Geodetic System of 1984

Source Map Scale Number:

Owner or Operator

Operator Name: Valley Fruit III, LLC
Operator Phone: (509) 877-4188

Mailing Address

Operator Street 1: 12 Hoffer Road

Operator Street 2:

Operator City: Wapato

Operator State: WASHINGTON

Operator ZIP: 98951
Operator ZIP4: 9519

Operator Foreign State or Province:

Operator Foreign ZIP: Operator Foreign Country:

Name and title of person or position responsible for Part 68 (RMP) Implementation

RMP Name of Person:

RMP Title of Person or Position:

RMP E-mail Address:

Bruce A. Frazier

General Manager

Bfrazier@sagefruit.com

Emergency Contact

Emergency Contact Name: Randy Mork

Emergency Contact Title: Refrigeration Engineer
Emergency Contact Phone: (509) 877-5268
Emergency Contact 24-Hour Phone: (509) 930-1542

Emergency Contact Ext. or PIN:

Emergency Contact E-mail Address: Rmork@sagefruit.com

Other Points of Contact

Facility or Parent Company E-mail Address:

Facility Public Contact Phone:

Facility or Parent Company WWW Homepage

Address:

Local Emergency Planning Committee

LEPC: Yakima County LEPC

220

Full Time Equivalent Employees

Number of Full Time Employees (FTE) on Site:

FTE Claimed as CBI:

Covered By

OSHA PSM : Yes

CAA Title V:

EPCRA 302 : Yes

Air Operating Permit ID:

OSHA Ranking

OSHA Star or Merit Ranking:

Last Safety Inspection

Last Safety Inspection (By an External Agency)

Date:

Last Safety Inspection Performed By an External

Agency:

17-Apr-2012

Washington State Pressure Vessel Inspection

Predictive Filing

Did this RMP involve predictive filing?:

Preparer Information

Preparer Name:

Preparer Phone:

Preparer Street 1:

Preparer Street 2:

Preparer City:

Preparer State:

Preparer ZIP:

Preparer ZIP4:

Preparer Foreign State:

Preparer Foreign Country:

Preparer Foreign ZIP:

Confidential Business Information (CBI)

CBI Claimed:

Substantiation Provided:

Unsanitized RMP Provided:

Reportable Accidents

Reportable Accidents:

See Section 6. Accident History below to determine if there were any accidents reported for this RMP.

Process Chemicals

Process ID: 1000039474

Description: ER2 - NH3 Refrigeration

Process Chemical ID: 1000047423

Program Level: Program Level 3 process
Chemical Name: Ammonia (anhydrous)

CAS Number: 7664-41-7

Quantity (lbs): 38181

CBI Claimed:

Flammable/Toxic: Toxic

Process ID: 1000039475

Description: ER1 - NH3 Refrigeration

Process Chemical ID: 1000047424

Program Level: Program Level 3 process
Chemical Name: Ammonia (anhydrous)

CAS Number: 7664-41-7

Quantity (lbs): 13984

CBI Claimed:

Flammable/Toxic: Toxic

Process NAICS

Process ID: 1000039474
Process NAICS ID: 1000039873

Program Level: Program Level 3 process

NAICS Code: 49312

NAICS Description: Refrigerated Warehousing and Storage

Process ID: 1000039475
Process NAICS ID: 1000039874

Program Level: Program Level 3 process

NAICS Code: 49312

NAICS Description: Refrigerated Warehousing and Storage

Section 2. Toxics: Worst Case

Toxic Worst ID: 1000032561

Percent Weight:

Physical State: Gas liquified by pressure

EPA's RMP Guidance for Ammonia Refrigeration Reference Tables or Equations Model Used:

Release Duration (mins): 10 Wind Speed (m/sec): 1.5 Atmospheric Stability Class: F Topography: Urban

Passive Mitigation Considered

Dikes:

Enclosures:

Yes

Berms: Drains: Sumps: Other Type:

Section 3. Toxics: Alternative Release

Toxic Alter ID: 1000034513

Percent Weight:

Physical State: Gas liquified by pressure

Model Used: EPA's RMP Guidance for Ammonia Refrigeration

Reference Tables or Equations

Wind Speed (m/sec):

Atmospheric Stability Class:

D

Topography:

Urban

Passive Mitigation Considered

Dikes:
Enclosures:
Berms:
Drains:
Sumps:
Other Type:

Active Mitigation Considered

Sprinkler System:
Deluge System:
Water Curtain:
Neutralization:
Excess Flow Valve:

Flares: Scrubbers:

Emergency Shutdown:

Other Type: Emergency Action Plan

Toxic Alter ID: 1000034512

Percent Weight:

Physical State: Gas liquified by pressure

Model Used: EPA's RMP_Guidance for Ammonia Refrigeration

Reference Tables or Equations

Wind Speed (m/sec):

Atmospheric Stability Class:

D

Topography:

Urban

Passive Mitigation Considered

Dikes: Enclosures: Berms: Drains: Sumps: Other Type:

Active Mitigation Considered

Sprinkler System: Deluge System: Water Curtain: Neutralization: Excess Flow Valve:

Flares:

Scrubbers:

Emergency Shutdown:

Other Type: Emergency Action Plan

Facility Name: Valley Fruit III, LLC
EPA Facility Identifier: 1000 0017 1075

Plan Sequence Number: 1000032321

Section 4. Flammables: Worst Case

Section 5. Flammables: Alternative Release

Facility Name: Valley Fruit III, LLC
EPA Facility Identifier: 1000 0017 1075

Plan Sequence Number: 1000032321

Section 6. Accident History

Section 7. Program Level 3

Description

No description available.

Program Level 3 Prevention Program Chemicals

Prevention Program Chemical ID: 1000040784

Chemical Name: Ammonia (anhydrous)

Flammable/Toxic: Toxic CAS Number: 7664-41-7

Process ID: 1000039474

Description: ER2 - NH3 Refrigeration

Prevention Program Level 3 ID: 1000034479 NAICS Code: 49312

Safety Information

Safety Review Date (The date on which the safety information was last reviewed or revised):

06-Dec-2012

Process Hazard Analysis (PHA)

PHA Completion Date (Date of last PHA or PHA update):

24-Apr-2008

The Technique Used

What If:

Checklist:

What If/Checklist:

Yes

HAZOP:

Failure Mode and Effects Analysis:

Fault Tree Analysis: Other Technique Used:

PHA Change Completion Date (The expected or actual date of completion of all changes resulting from last PHA or PHA update):

14-Jan-2010

Major Hazards Identified

Toxic Release: Yes

Fire: Yes

Explosion:

Runaway Reaction:

Polymerization:

Overpressurization: Yes Corrosion: Yes

Overfilling: Contamination:

Equipment Failure: Yes

Loss of Cooling, Heating, Electricity, Instrument Air:

Facility Name: Valley Fruit III, LLC EPA Facility Identifier: 1000 0017 1075 Plan Sequence Number: 1000032321 Earthquake: Yes Floods (Flood Plain): Tornado: Hurricanes: Other Major Hazard Identified: **Process Controls in Use** Vents: Relief Valves: Yes Check Valves: Yes Scrubbers: Flares: Manual Shutoffs: Yes Automatic Shutoffs: Yes Interlocks: Yes Alarms and Procedures: Yes Keyed Bypass: Emergency Air Supply:

Keyed Bypass:
Emergency Air Supply:
Emergency Power:
Backup Pump:
Grounding Equipment:

Grounding Equipment:
Inhibitor Addition:
Rupture Disks:
Excess Flow Device:
Quench System:
Purge System:

None:

Other Process Control in Use:

Mitigation Systems in Use

Sprinkler System:

Dikes: Fire Walls:

Yes

Blast Walls: Deluge System: Water Curtain:

Enclosure: Yes

Neutralization:

None:

Other Mitigation System in Use:

Monitoring/Detection Systems in Use

Process Area Detectors:

Yes

Perimeter Monitors:

None:

Other Monitoring/Detection System in Use: Engine Rooms

Changes Since Last PHA Update

Reduction in Chemical Inventory: Increase in Chemical Inventory: Change Process Parameters:

Installation of Process Controls:

Installation of Process Detection Systems: Yes

Installation of Perimeter Monitoring Systems:

Installation of Mitigation Systems:

None Recommended:

None:

Other Changes Since Last PHA or PHA Update:

Review of Operating Procedures

Operating Procedures Revision Date (The date of the most recent review or revision of operating procedures):

28-Dec-2012

Training

Training Revision Date (The date of the most recent 06-Dec-2012 review or revision of training programs):

The Type of Training Provided

Classroom: Yes
On the Job: Yes

Other Training:

The Type of Competency Testing Used

Written Tests: Yes

Oral Tests:

Demonstration: Yes

Observation:

Other Type of Competency Testing Used:

Maintenance

Maintenance Procedures Revision Date (The date of 25-May-2012 the most recent review or revision of maintenance procedures):

Equipment Inspection Date (The date of the most recent equipment inspection or test):

19-Jun-2012

Equipment Tested (Equipment most recently inspected or tested):

Pressure Vessel Inspection

Management of Change

Change Management Date (The date of the most recent change that triggered management of change procedures):

26-Jul-2011

Change Management Revision Date (The date of 06-Dec-2012 the most recent review or revision of management of change procedures):

Pre-Startup Review

Pre-Startup Review Date (The date of the most recent pre-startup review):

06-Dec-2012

Compliance Audits

Compliance Audit Date (The date of the most recent 06-Dec-2012 compliance audit):

Compliance Audit Change Completion Date (Expected or actual date of completion of all changes resulting from the compliance audit):

18-Dec-2013

Incident Investigation

Incident Investigation Date (The date of the most recent incident investigation (if any)):

Incident Investigation Change Date (The expected or actual date of completion of all changes resulting from the investigation):

Employee Participation Plans

Participation Plan Revision Date (The date of the most recent review or revision of employee participation plans):

06-Dec-2012

Hot Work Permit Procedures

Hot Work permit Review Date (The date of the most 06-Dec-2012 recent review or revision of hot work permit procedures):

Contractor Safety Procedures

Contractor Safety Procedures Review Date (The date of the most recent review or revision of contractor safety procedures):

06-Dec-2012

Contractor Safety Performance Evaluation Date (The date of the most recent review or revision of contractor safety performance):

06-Dec-2012

Confidential Business Information

CBI Claimed:

Description

No description available.

Program Level 3 Prevention Program Chemicals

Prevention Program Chemical ID: 1000040785

Chemical Name: Ammonia (anhydrous)

Flammable/Toxic: Toxic CAS Number: 7664-41-7

Process ID: 1000039475

Description: ER1 - NH3 Refrigeration

Prevention Program Level 3 ID: 1000034480 NAICS Code: 49312

Safety Information

Safety Review Date (The date on which the safety information was last reviewed or revised):

06-Dec-2012

Process Hazard Analysis (PHA)

PHA Completion Date (Date of last PHA or PHA

update):

24-Apr-2008

The Technique Used

What If:

Checklist:

What If/Checklist:

Yes

HAZOP:

Failure Mode and Effects Analysis:

Fault Tree Analysis: Other Technique Used:

PHA Change Completion Date (The expected or actual date of completion of all changes resulting from last PHA or PHA update):

14-Jan-2010

Major Hazards Identified

Toxic Release: Yes

Fire: Yes

Explosion:

Runaway Reaction:

Polymerization:

Overpressurization: Yes Corrosion: Yes

Overfilling: Contamination:

Equipment Failure: Yes

Loss of Cooling, Heating, Electricity, Instrument Air:

Earthquake: Yes

Facility Name: Valley Fruit III, LLC EPA Facility Identifier: 1000 0017 1075 Plan Sequence Number: 1000032321 Floods (Flood Plain): Tornado: Hurricanes: Other Major Hazard Identified: **Process Controls in Use** Vents: Relief Valves: Yes Check Valves: Yes Scrubbers: Flares: Manual Shutoffs: Yes Automatic Shutoffs: Yes Interlocks: Yes Alarms and Procedures: Yes Keyed Bypass: Emergency Air Supply: **Emergency Power:** Backup Pump: Grounding Equipment: Inhibitor Addition: Rupture Disks: **Excess Flow Device:** Quench System: Purge System: None: Other Process Control in Use: Mitigation Systems in Use Sprinkler System: Dikes: Fire Walls: Yes Blast Walls: Deluge System: Water Curtain: Enclosure: Yes Neutralization: None: Other Mitigation System in Use:

Monitoring/Detection Systems in Use

Process Area Detectors: Yes

Perimeter Monitors:

None:

Other Monitoring/Detection System in Use: Engine Rooms

Changes Since Last PHA Update

Reduction in Chemical Inventory:

Increase in Chemical Inventory:

Change Process Parameters:

Installation of Process Controls:

Installation of Process Detection Systems:

Installation of Perimeter Monitoring Systems:

Installation of Mitigation Systems:

None Recommended:

None:

Other Changes Since Last PHA or PHA Update:

Review of Operating Procedures

Operating Procedures Revision Date (The date of the most recent review or revision of operating procedures): 28-Dec-2012

Yes

Training

Training Revision Date (The date of the most recent 06-Dec-2012 review or revision of training programs):

The Type of Training Provided

Classroom: Yes On the Job: Yes

Other Training:

The Type of Competency Testing Used

Written Tests: Yes

Oral Tests:

Demonstration:

Yes

Observation:

Other Type of Competency Testing Used:

Maintenance

Maintenance Procedures Revision Date (The date of 25-May-2012 the most recent review or revision of maintenance procedures):

Equipment Inspection Date (The date of the most recent equipment inspection or test):

19-Jun-2012

Equipment Tested (Equipment most recently inspected or tested):

Pressure Vessel Inspection

Management of Change

Change Management Date (The date of the most recent change that triggered management of change procedures):

26-Jul-2011

Change Management Revision Date (The date of the most recent review or revision of management of change procedures):

Pre-Startup Review

Pre-Startup Review Date (The date of the most recent pre-startup review):

06-Dec-2012

Compliance Audits

Compliance Audit Date (The date of the most recent 06-Dec-2012 compliance audit):

Compliance Audit Change Completion Date (Expected or actual date of completion of all changes resulting from the compliance audit):

18-Dec-2013

Incident Investigation

Incident Investigation Date (The date of the most recent incident investigation (if any)):

Incident Investigation Change Date (The expected or actual date of completion of all changes resulting from the investigation):

Employee Participation Plans

Participation Plan Revision Date (The date of the most recent review or revision of employee participation plans):

06-Dec-2012

Hot Work Permit Procedures

Hot Work permit Review Date (The date of the most 06-Dec-2012 recent review or revision of hot work permit procedures):

Contractor Safety Procedures

Contractor Safety Procedures Review Date (The date of the most recent review or revision of contractor safety procedures):

06-Dec-2012

Contractor Safety Performance Evaluation Date (The date of the most recent review or revision of contractor safety performance):

06-Dec-2012

Confidential Business Information

CBI Claimed:

Facility Name: Valley Fruit III, LLC

EPA Facility Identifier: 1000 0017 1075

Section 8. Program Level 2 Plan Sequence Number: 1000032321

Section 9. Emergency Response

Written Emergency Response (ER) Plan

Community Plan (Is facility included in written community emergency response plan?):

Yes

Facility Plan (Does facility have its own written emergency response plan?):

Response Actions (Does ER plan include specific actions to be taken in response to accidental releases of regulated substance(s)?):

Public Information (Does ER plan include procedures for informing the public and local agencies responding to accidental release?):

Healthcare (Does facility's ER plan include information on emergency health care?):

Emergency Response Review

Review Date (Date of most recent review or update of facility's ER plan):

Emergency Response Training

Training Date (Date of most recent review or update of facility's employees):

Local Agency

Agency Name (Name of local agency with which the Wapato City FD, Yakima Cnty Dist 5 facility ER plan or response activities are coordinated):

Agency Phone Number (Phone number of local agency with which the facility ER plan or response activities are coordinated):

(508) 877-7148

Subject to

OSHA Regulations at 29 CFR 1910.38: Yes
OSHA Regulations at 29 CFR 1910.120: Yes

Clean Water Regulations at 40 CFR 112:

RCRA Regulations at CFR 264, 265, and 279.52: OPA 90 Regulations at 40 CFR 112, 33 CFR 154,

49 CFR 194, or 30 CFR 254:

State EPCRA Rules or Laws: Yes

Other (Specify):

Executive Summary

Accidental Release Prevention and Emergency Action Policies

The Valley Fruit emergency action policies are designed to provide the following:

- 1. To protect the lives of plant personnel and the constituents within the zone of influence.
- 2. For the purpose of mitigating personal injury.
- 3. To minimize damage to property and the environment.

There is a Safety Committee that meets periodically to coordinate safety programs. The facility has two employees that are trained to the First Responder Technician Level in accordance with the HAZWOPER regulations. These two refrigeration technicians can assist the local emergency response team in the event of an incident.

Stationary Source and Regulated Substance

Location of Valley Fruit facility is 12 Hoffer Road in Wapato, Washington. Engine Room #1 was constructed in 1988 and Engine Room #2 was constructed in 1995.

The facility uses ammonia as a refrigerant for the cold storage of agricultural products. A mechanical refrigeration system is a closed system that cycles the refrigerant, ammonia, from liquid to gas and back again. As the refrigerant absorbs large amounts of heat from the source, the refrigerant changes from liquid to gas. At a different part of the system, the refrigerant releases heat as it is condensed back into a liquid.

There are two separate ammonia refrigeration systems. Engine Room #1 and Engine Room #2.

Accidental Release Prevention Program and Chemical-Specific Prevention Steps

Practices and procedures (SOP'S) for proper ammonia handling are obtained through annual Emergency Response Training that is specifically targeted toward ammonia refrigeration safety. In addition to plant safety policies for the safe handling of ammonia, there are ammonia gas detectors in the cold storage rooms. These sensors activate an automatic dialer system and Engine Room detection notification at 50 ppm to notify the front office, Maintenance Manager, and Refrigeration Engineer.

Five Year Accident History

The facility has had no reportable releases of ammonia during the last five years.

Emergency Action Plan

The facility has an emergency action plan and will evacuate all affected areas and notify local emergency responders. However the facility has two trained emergency responders which can assist the local emergency response team in the event of a release. These two responders are the refrigeration technicians who have received an initial 24 hour training program with 8 hour annual refresher training specifically relating to ammonia refrigeration safety.

Planned Changes to Improve Safety

There is ongoing assessment of the ammonia systems by annual mechanical integrity audits and SOP review, five year mechanical integrity audits including periodic audits of the entire program.